



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6500X01611W142B-3T-

1

Job Sheet 190249



Part No: RBW6500X01611W142B-3T-1 **Job Qty:** 2 pcs

Part Name: Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6500X01611W142B-3T Rev.2 IPP Rev. A 19.02.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	2 pcs	3/18/19	3/18/19	0.00	0.40	Waterjet - Omax	α 19/02/19
110	QC 2	2 pcs	3/18/19	3/18/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	α 19/02/19
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



Container No: S153687

Part: RBW6500X01611W142B-3T-1

Job No: 190249

Serial No/Batch: S153687

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/13/19

120 NV5000 - 1 - B4B	2 pcs	3/18/19	0.00 2.00	NV5000 - 1 - B4B	PJ 19-02-21
				NV5000 - 2 - B4B	
130 QC 2	2 pcs	3/18/19	0.00 0.00	QC 2 - 1	PJ 19-02-21
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 38	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
140 QC 8	2 pcs	3/18/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	D.A. 19-02-23
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 47	
150 Outsource - 12 - Black Oxide	2 pcs	3/18/19		GRO002-VC	GC 19-02-26
160 Packaging 2-1 - Receive - B4B	2 pcs	3/18/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Plex 2/6/19 10:01 AM Dart.lajeunesse.marie	

				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
170	QC 6	2 pcs	3/18/19	0.00 0.00	QC 6 - 38
					QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
180	Packaging 3-1 - Stock - B4B	2 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Plex 2/6/19 10:01 AM Dart.lajeunesse.mari

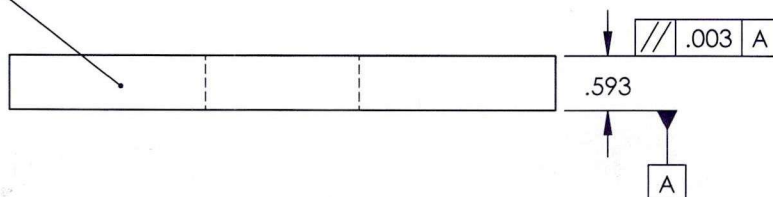
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
190	QC 21 - SA	2 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
Part Op 100 - 1-Cut as per DWG. DWG. Rev: _____ PROG. Rev: _____ 2-Deburr if necessary Descriptions: 120 - 1-Machine as per folio FC _____ FOLIO REV: _____ DWG REV: _____ 2-Deburr 140 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG. 150 - -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required 160 - -Certificate of Conformity is required					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-HRS-P-0.625	Hot Rolled Steel Plate 0.625" thk	.2420 sf (.121 ea)	100-Waterjet - Omax - 1		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Omax - 1	MT-HRS-P-0.625	0	25	0	
Part Specifications					
Specifications could not be found.					

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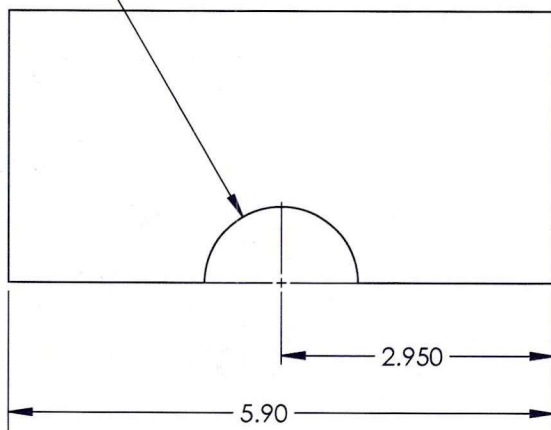
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		DELETED -1 ENGRAVE "DTE 1" AND "KPE 1".	12/21/2012	RJC	SE
2	16-0071	-1 CH'D MATERIAL WAS 1018 IS A36/1018/1020 HR, CH'D ENGRAVE NOTE WAS ENGRAVE T/N "RBW6500X01611W142B-3T" IS ENGRAVE T/N, S/N, "MADE IN USA", CH'D DIM WAS 2.955 IS 2.955 ±.03.	7/12/2016	RJC	SM

ENGRAVE T/N, S/N,
"MADE IN USA"

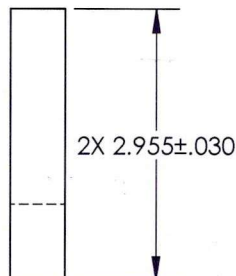
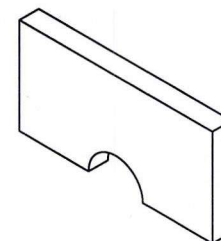


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PLATE



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 190249
190246

DART
AEROSPACE

TITLE
SHAFT SUPPORT BEARING REMOVAL

DWG NO. RBW6500X01611W142B-3T-1 REV 2

MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH BLACK OXIDE		.XX ± .005	FRACTIONS ± 1/8
SPEC QMSI-6.2.2 REV D		.XX ± .01	ANGLES ± 5°
DRAWN BY: CLOUGH		.X ± .1	SURFACES = 125/
CHECKED: DUERFELDT		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: MACKOVJAK		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER	
DATE 10/14/2012		ASME Y14.5M-2009	
		USED ON MODEL	
		AW139	
		SHEET 2 OF 3	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Email: sales@dartaero.com
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Container No: S153687



Part: RBW6500X01611W142B-3T-1

Job No: 190249

Serial No/Batch: S153687

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 02/14/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042706



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042706
PO Date: 2/26/19
Due Date: 3/5/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189242	RBE-350DAMPER	Damper Spanner Wrench -Issue P/O; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	3/5/19	5 pcs	0 pcs	5 pcs	\$2.35/pcs	\$11.75
2	191018	RBEVR-L11-0010-002-D-1	Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/5/19	4 pcs	0 pcs	4 pcs	\$14.13/pcs	\$56.52



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PURCHASE ORDER PO042706



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	188149	RBE1X56-122-294-5	Threaded Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/5/19	6 pcs	0 pcs	6 pcs	\$2.35/pcs	\$14.10
4	190249	RBW6500X01611W142B-3T-1	Plate -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	3/5/19	4 pcs	0 pcs	4 pcs	\$5.71/pcs	\$22.84
5	189454	RBT18565-1	Hex Bit -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	3/5/19	10 pcs	0 pcs	10 pcs	\$1.10/pcs	\$11.00

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4 X MAR 13 2019

10 X MAR 13 2019

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PURCHASE ORDER

PO042706



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	188147	RBE1X56-122-294-1	Outside Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/5/19	5 pcs	0 pcs	5 pcs	\$4.71/pcs	\$23.55
7	191015	RBEVR-L11-0010-002-B-3	Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	3/5/19	4 pcs	0 pcs	4 pcs	\$14.13/pcs	\$56.52
Grand Total:										\$196.28	



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PURCHASE ORDER PO042706



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/8/19 11:15 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017229- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
06-Mar-2019		Shankar Anand		042706				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE-350DAMPER Rev. ✓	RBE-350DAMPER 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	5	5 ✓	0	0	0
2	RBEVR-L11-0010-002-D-1 Rev. ✓	RBEVR-L11-0010-002-D-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4 ✓	0	0	0
3	RBE1X56-122-294-5 Rev. ✓	RBE1X56-122-294-5 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OR OIL WIPE OFF EXCESS OIL	OXIDE-BLACK CH	6	6 ✓	0	0	0
4	RBW6500X01611W142B-3T-1 Rev. ✓	RBW6500X01611W142B-3T-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4 ✓	0	0	0
5	RBT18565-1 Rev. ✓	RBT18565-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	10	10 ✓	0	0	0
6	RBE1X56-122-294-1 Rev. ✓	RBE1X56-122-294-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	5	5 ✓	0	0	0
7	RBEVR-L11-0010-002-B-3 Rev. ✓	RBEVR-L11-0010-002-B-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4 ✓	0	0	0

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Page 2 of 2